

Work Order ID 53612

November 10, 2009 11:51:54 AM



Page 1

Item ID: D3836-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 11/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/12/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3836	Rev A								
100	Large Fab	0.00	<i>09.11.10</i>						<i>* custom made for DSI 9473 conversion</i>
Large Fab	Memo	0.00							
Large Fab	1- cut D3836-2 and D3836-3 rib as per dwg D3836-2- remove identification markings-13- deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
120	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1- weld D3836-2 to D3836-3 and drill hole (3/16") using D38447 jig and open to finish size as per dwg D3836-1- weld D2327-3 spacer bushing as per dwg D3836-1 A/R ER316 S.S. Rod Batch: <i>4109213</i> -3- grind weld flush where indicated on dwg D								<i>DSI 9473</i>

SY 09/11/10 (1x)
PD 09.11.10 (1x)

SY 09/14/10 (1x)

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Item ID: D3836-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 11/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/12/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

CP 02 11 10

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 05.11.10

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Basket 04

09/11/10 (1x)

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Page 3

Item ID: D3836-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 11/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/12/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/11
MF
09-11-11

Picklist Print

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Page 1

Work Order ID: 53612

Parent Item: D3836-042RevA

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 11/10/09

Required Date: 11/12/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3RevD Spacer Bushing		Manufactured	No			100	Each	32.0000	1.0000			

N/A

09.11.11

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	32	
44274	13	
44365	9	
51126	10	

M304TS0.750W.065

Purchased

No

100

f

481.2115

1.8745



304 SQ Tube .75x.75x.065W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	473.6842	
113082	473.6842	
Main Warehouse		
WA	7.5272947	
112398	7.5272947	

1.8745

09/11/10

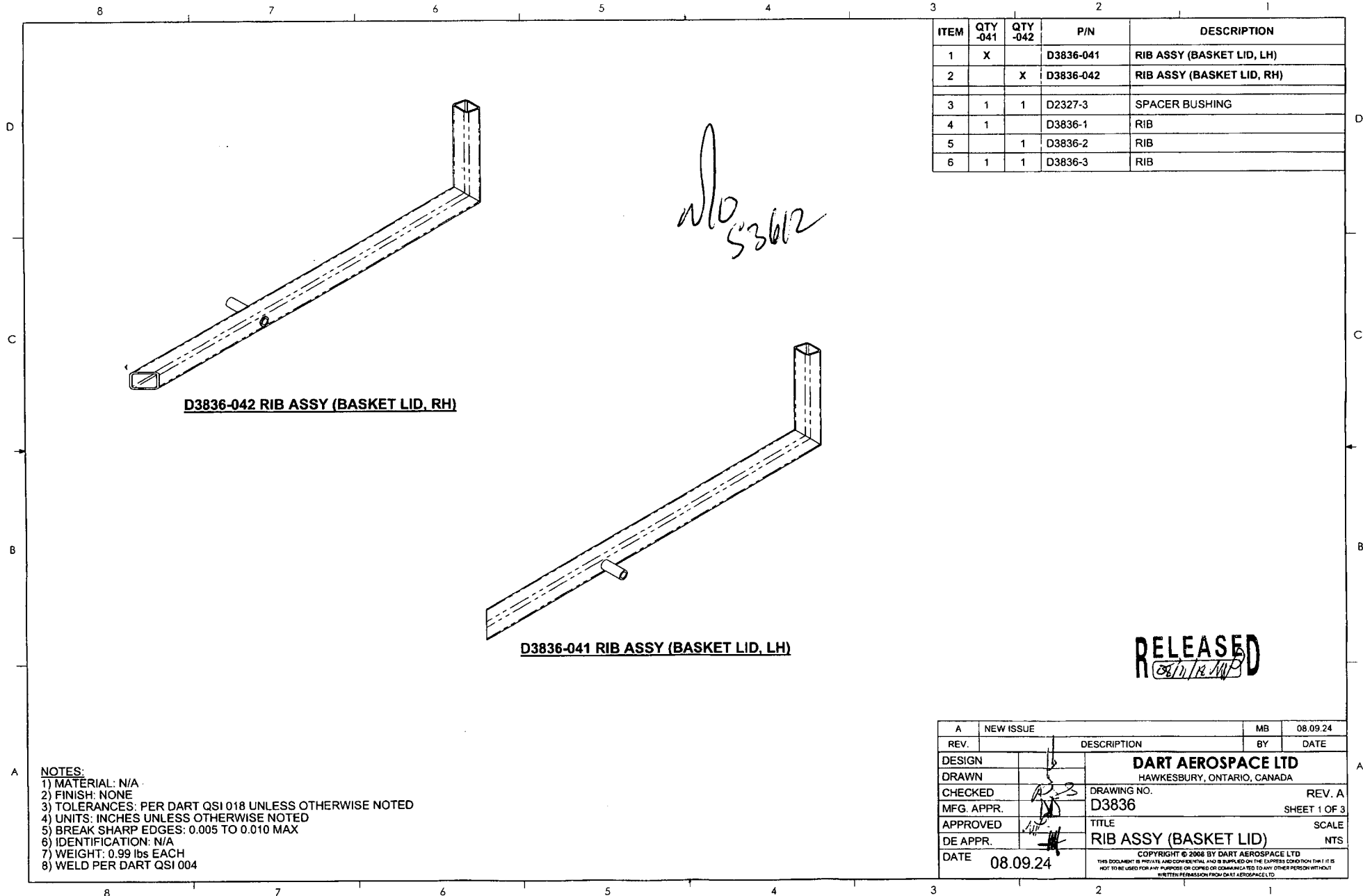
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

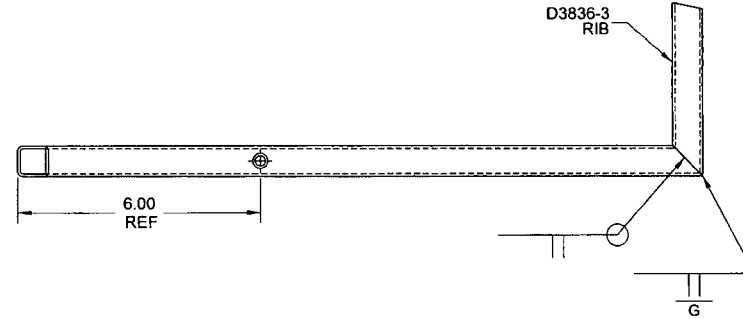
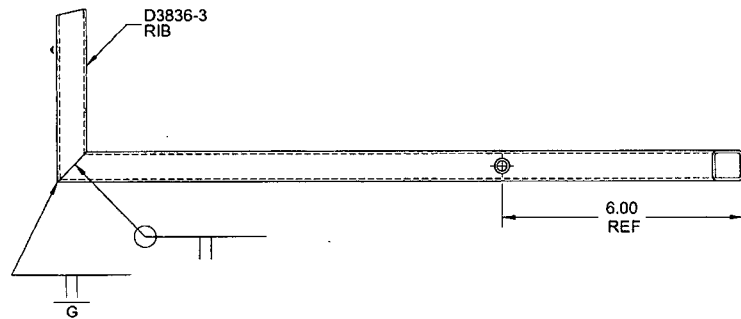
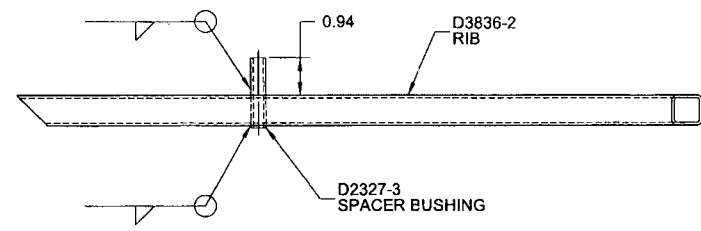
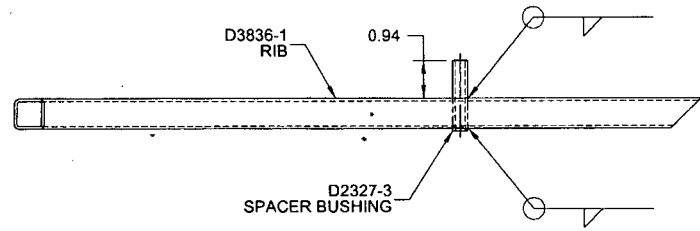
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



u/o 53612



D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

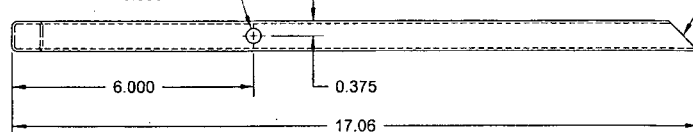
RELEASED
08/11/14 JMT

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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CHAMFER



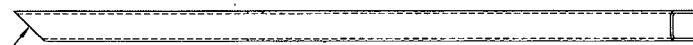
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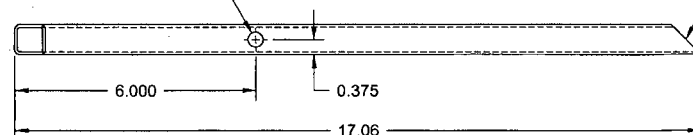
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D3836-1 RIB

0.75 X 45°
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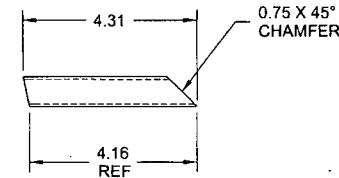


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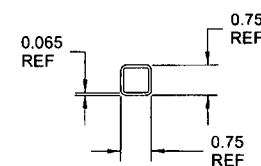


0.75 X 45°
CHAMFER

D3836-2 RIB



D3836-3 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/84

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

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W/O 53612

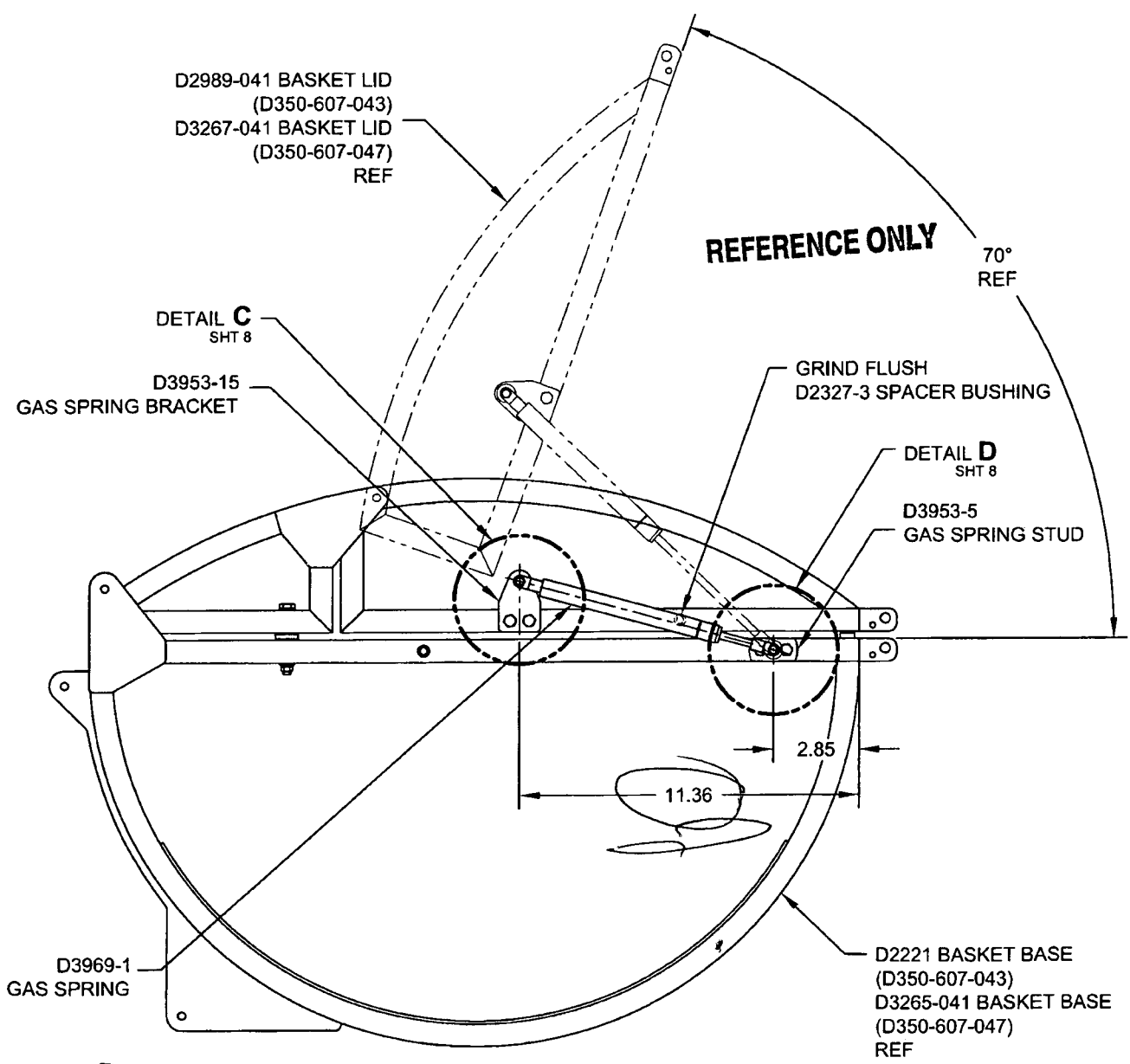


FIGURE 2
D350-607-143 GAS SPRING KIT INSTALLATION
 (1 END ONLY)

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED
 BY: *[Signature]*
 D. SHEPHERD (DE # 02)

DATE: 09.09.15
 CERT. NO.: SH94-14
 ISSUE NO.: 4

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9473	SHEET 6 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING UPGRADE KIT	NTS
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